

633-013

Dart Aerospace Ltd.

Date: Wednesday, 29/04/2009 3:01:05 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 47597A			Part Number	: D2563	
Estimate Number	: 10176			Drawing Number	: D2563 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 29/04/2009		S.O. No. :	Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type	: LARGE FAB ASSY		
Previous Run	: 47412A			Due Date	: 05/05/2009	
Written By	:			Qty:	4	
Checked & Approved By	: JUD 09.04.29			Um:	Each	
Comment	: Est Rev:G 02.07.31 Re-format Location RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick: 1 D2244 Step Extrusion	
		Batch: 33733 (3) 38023 (1) SAD 09-05-06 (4)	
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2673-34 End Cap 335887	
3.0	D2561	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2561 Lug Plate 340935	
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Pick: Qty Part No. Description Batch	
		2 D2564 Mounting Angle 340936	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 47597A		Part Number: D2563
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2244 to 89.70" at 34 deg as per dwg D2563		
SAD 09-05-06 (4)		
2-Deburr ends		
SAD 09-05-06 (4)		
3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343		
A/R AL ROD Batch: <u>M110972</u> <u>M110130</u>		
S2 09-05-08 4		
4- Grind		
6.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		
7.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Inspect for foreign object per QSI 024		
S2 09-05-12 4		
2-Weld Remaining End as per Dwg D2563 using DT 8343		
A/R AL ROD Batch: <u>M110130</u>		
S2 09-05-12 4		
3-Grind		
SAD 09-05-12		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-13 (4)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (X4)

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then => 09/05/13 X4 21

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(X4)

START TIME: 14:00

OVEN TEMPERATURE: 320°

FINISH TIME: 14:30 CMO

09/05/14

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



1111013

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

9/10/14 - 05-19 X4

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/9/14 20 (4)

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/21 (4)

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

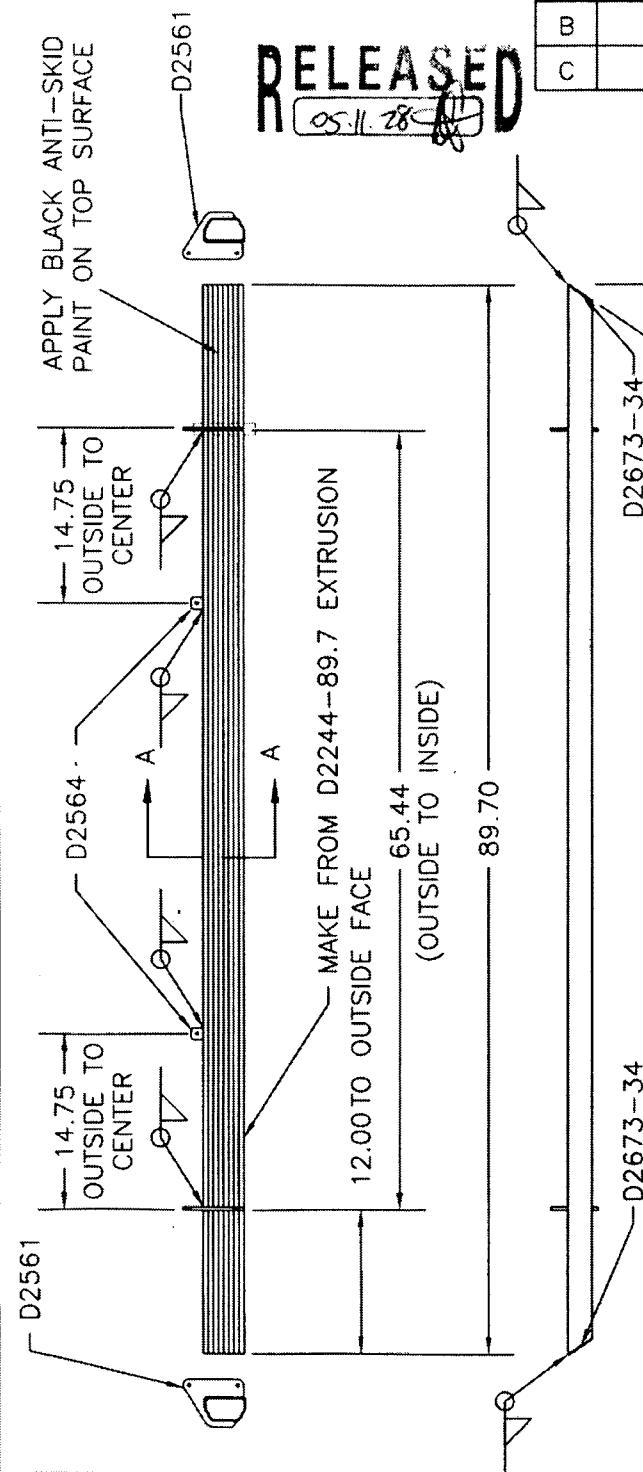
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>PJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2563
		REV. C
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	SCALE 1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES

RELEASED
05.11.28.04



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	SLUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing
F.O.T. TO AMENDMENT
NOTICE
WORK ORDER
[initials]

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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